



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4635-144
Job Sheet 191338



008378

Part No: D4635-144

Job Qty: 1 pcs

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/19

Job Tracking No: siop

Due Date: 3/29/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 12 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	3/29/19		0.00	1.57	Small Fab - 1		DAS 58 9-89 MAR 12 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	3/29/19		0.00	0.00	QC 5 - 10		D 19-03-13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

				Packaging 3 - 7 - B4B	DAS 58
				Packaging 3 - 8 - B4B	9-89 MAR 13 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	DAS 70
				QC 21 - SA - 70	MAR 13 2019
				QC 21 - SA - 53	9-89

Part Op 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: m131557 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # m138999 Expiry Date 07/19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138961
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____) identify as per dwg & Stock Location: _____
 140 - (QC21- Final Inspection - Work Order Release)QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-4	Aft Ceiling Panel, RH	1 Ea (1 ea)	110-Small Fab - 1	5053616
D4669-1	Bracket	1 Ea (1 ea)	110-Small Fab - 1	5122232
D4695-4	Channel	1 pcs (1 ea)	110-Small Fab - 1	5158716
D4732-11	Label	1 pcs (1 ea)	110-Small Fab - 1	5060828
D4732-39	Label	1 pcs (1 ea)	110-Small Fab - 1	5060912
D4732-41	Label	1 pcs (1 ea)	110-Small Fab - 1	5060916
D5022-5	Foam, Side Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	5017750

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4635-4	1	5	0
	D4669-1	1	27	0
	D4695-4	1	0	0
	D4732-11	1	3	0
	D4732-39	1	3	0
	D4732-41	1	3	0
	D5022-5	1	5	0

Part Specifications
Specifications could not be found.

Plex 2/27/19 10:22 AM dart.lacelle.linda



Container No: S161381



Part: D4635-144

Job No: 191338

Serial No/Batch: S161381

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

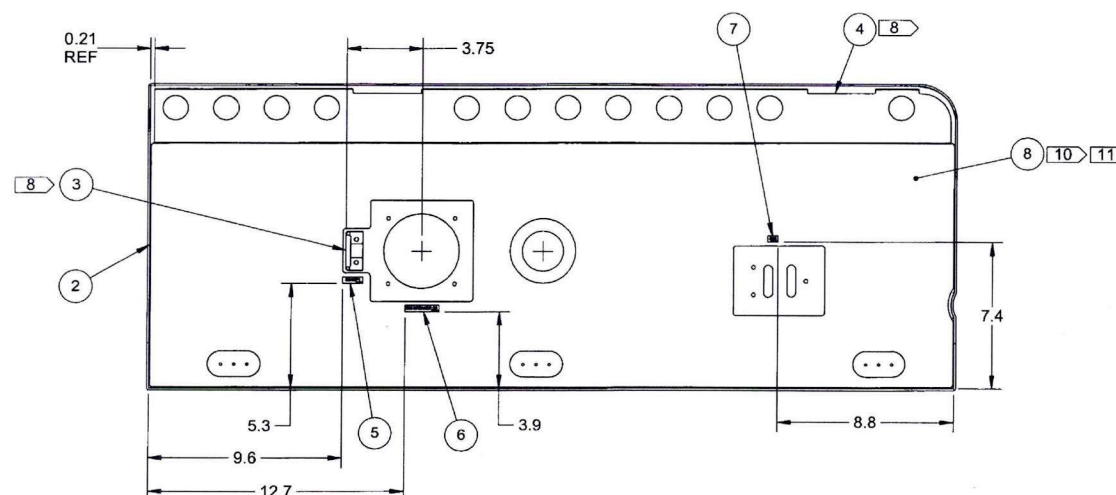
TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 03/12/19

ITEM	QTY	P/N	DESCRIPTION
1	X	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
2	1	D4635-4	RH, AFT CEILING PANEL
3	1	D4669-1	BRACKET
4	1	D4695-4	CHANNEL
5	1	D4732-11	LABEL
6	1	D4732-39	LABEL
7	1	D4732-41	LABEL
8	1	D5022-5	FOAM, SIDE PANEL, AFT, RH



D4635-144 RH, AFT CEILING REPLACEMENT PANEL ASSY

RELEASED

2015 JAN 26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-4. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-5 FOAM ON D4635-4

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. F
	MFG. APPR.	DL	D4635	SHEET 12 OF 18
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE		14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	